

Date: Thursday, 3/13/2008 10:20:29 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 37931		
Estimate Number	: 10710		
P.O. Number	:	Part Number	: D32111
This Issue	: 3/13/2008 S.O. No. :	Drawing Number	: D3211 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 37677	Material	:
Written By	:	Due Date	: 3/25/2008
Checked & Approved By	: <u>08 03 13</u>	Qty:	1500 Um: Each
Comment	: Est Rev:A New Issue 05-11-17 JLM Est Rev:B Now on Waterjet 06-10-24 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 1.4753 sf(s)/Unit Total : 14.7525 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.063" thick
(M2024T3S.063)Identify as D3211-1
Batch: 105615 HB 8-3-26

106 223 x 2 + 1 + 3 = 5
19059 x 1 + 1 = 2
104921 x 1 = 1 + 8

2.0 WATER JET 4+2+1 FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3211
Dwg Rev: A1
Prog Rev: A1

HB 8-3-26

13

2-Deburr if necessary

HB 8-3-26

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-3-26

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8 08/03/26 (HB)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1


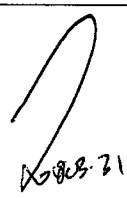

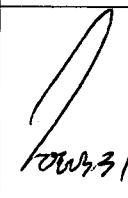


Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

4 Done at 2/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3211-1 PAR #: N/A Fault Category: Prod/Prod Ass ^{needed simple} NCR: Yes No DQA: D Date: 02/04/04
D350-567 QA: N/C Closed: D Date: 02/04/04

NCR: 37931		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
02/03/31	6	2 piece broke at the bend	 02/03/02	Scrap & destroy No replace	SA 02/03/31	 02/03/31	 02/03/02	 02/03/31

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 37931

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

SB 08/04/01

(11)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/04/01 (11)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-04-01

(11)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BL 08-04-02

(11)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/04/02

(11K)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/4/2

SC

(11X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03

Job Completion



mf

08-04-02

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

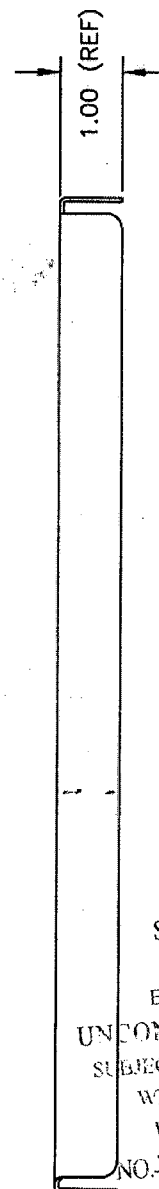
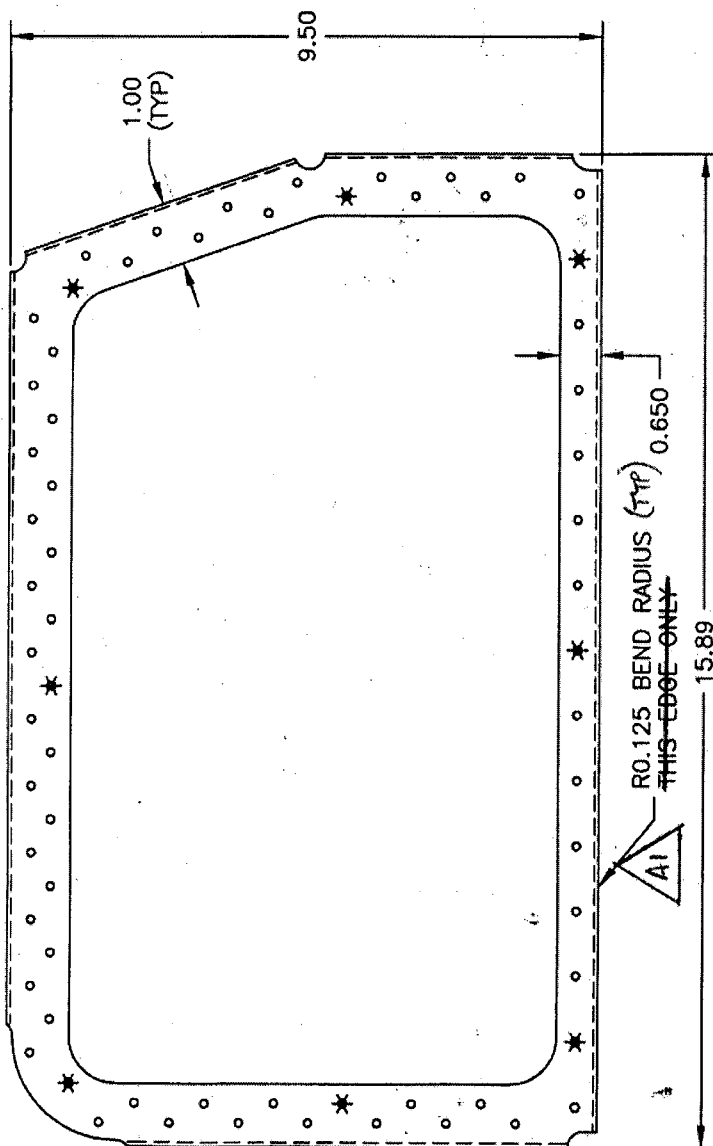
NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. A
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO. D3211	SHEET 1 OF 2
DATE	03.09.03	TITLE	BRACKET	SCALE	1:3
A	03.09.03	NEW ISSUE			
A1	[Signature] 03.12.05	CHANGE ALL BEND RADI TO R0.125			

RELEASED
03.09.15

D3211-1 BRACKET
MACHINE PER DRAWING FILE "D3211-A2.DWG"
CHECK PER TEMPLATE D3211-1T1
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
USE MINIMUM BEND RADIUS OF $\phi 188$ EXCEPT WHERE INDICATED $\phi 125$
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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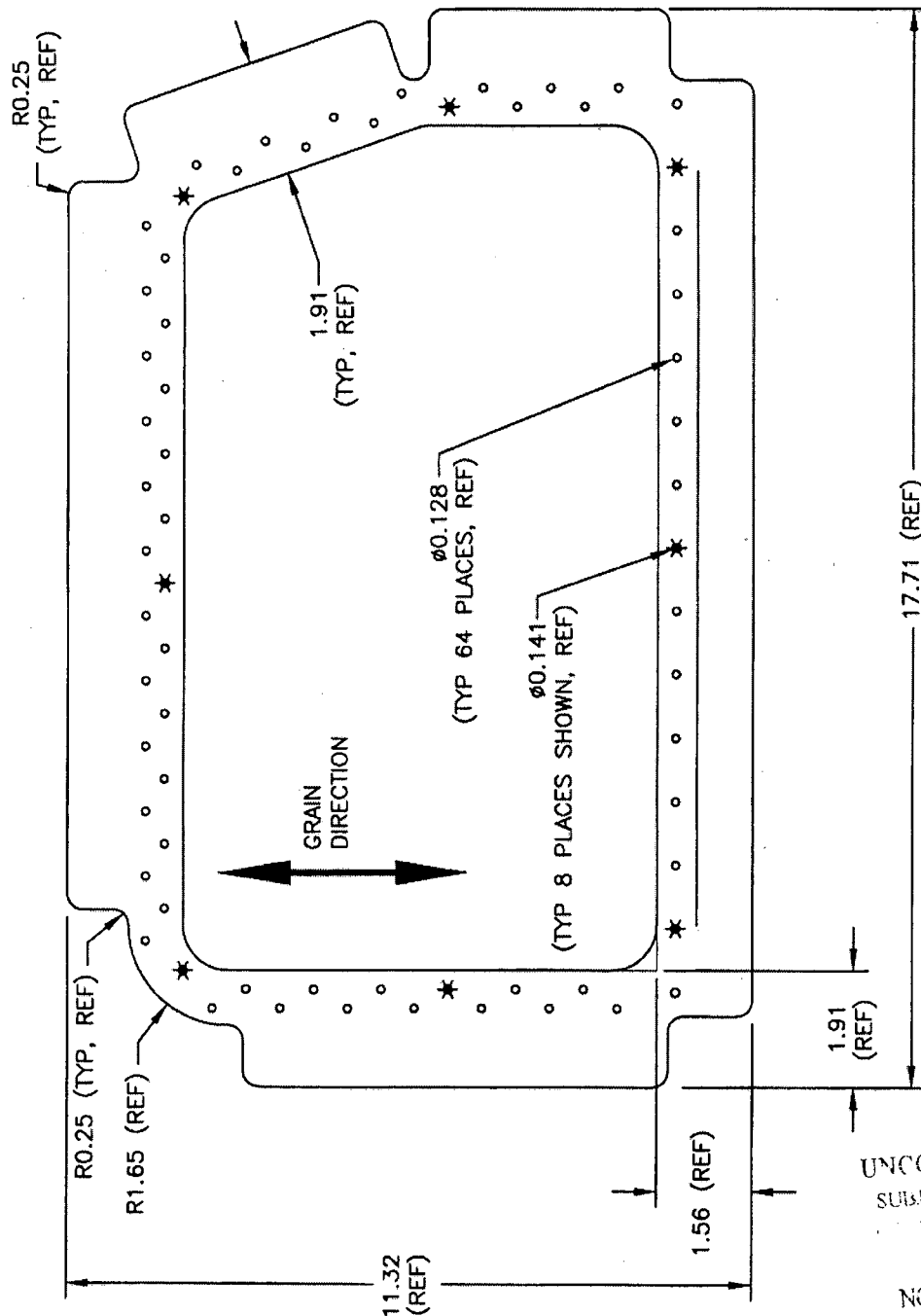
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03	TITLE BRACKET		SCALE 1:3

RELEASED
03.09.15

D3211-1 FLAT PATTERN



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